

Work Order ID 163353

Tuesday, June 27, 2017 1:05:54 PM

163353

Page 1

Item ID: D2582 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hi-Skid Step Leg Assembly
 Start Date: 6/27/2017 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/3/2017 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: 21 Date: JUN 27 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2582	Rev B ✓

100		0.00							
100	Small Fab								
Small Fab	Memo	1.56							
Small Fab	Assemble as per Dwg D2582 and								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.20							
Quality Control									

120	Identify as per dwg & Stock Location:	0.00							
120									
Packaging	Memo	0.10							
Packaging	LOCATION WA003								

DAS
36
9-89

DAS
30
9-89

DAS
30
9-89

JUL 26 2017

JUL 26 2017

10X

17/07/16

10

10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Item ID: D2582

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Hi-Skid Step Leg Assembly

Start Date: 6/27/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/3/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

1.00

Quality Control

DAG
21
9-89

JUL 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

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Work Order ID: 163353

163353

Parent Item: D2582

D2582

Parent Item Name: Hi-Skid Step Leg Assembly

Start Date: 6/27/2017

Required Date: 7/3/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:F Removed Manufacturing 05-11-07 JLM
 IPP Rev:G Added part # to Sub 06-08-10 JLM
 IPP Rev H New pick list 08.01.11 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2278 *D2278* Step Leg		Manufactured	No			100	Each	11.0000	2	20			DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				GA				11				17/07/26	
				158243				1				163729	(10x)
				162908				10				163480	(9x)
D2279 *D2279* Step Spacer		Manufactured	No			100	Each	17.0000	1	10			DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				GA				17				17/07/26	
				155520				12					
				158232				5					
D2322 *D2322* Step Spacer		Manufactured	No			100	Each	18.0000	1	10			DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				GA				18				17/07/26	
				152246				6					
				154915				2					
				162879				10					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																							
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Parent Item: D2582

D2582

Parent Item Name: Hi-Skid Step Leg Assembly

Start Date: 6/27/2017

Required Date: 7/3/2017

Start Qty: 10.00

Required Qty: 10.00

D3720-1 Manufactured No 100 Each 15.0000 1 10

D3720-1

Step Spacer

**

17/07/2017 DAS 36 9-89

Location	Loc Qty	Loc Code
GA	15	
157304	3	
159109	12	

D3720-2 Manufactured No 100 Each 6.0000 1 10

D3720-2

Step Spacer

**

17/07/2017 DAS 36 9-89

Location	Loc Qty	Loc Code
GA	6	
154217	6	

MS20470AD4-4 Purchased No 100 Each 2,548.000 22 220

MS20470AD4-4

Rivet, Universal Head

**

17/07/2017 DAS 36 9-89

Location	Loc Qty	Loc Code
GA	2168	
M136851	181	
M137166	153	
M137371	1834	
ST310	380	
M132803	380	

MS20470AD4-5 Purchased No 100 Each 1,601.000 4 40

MS20470AD4-5

RIVET, UNIVERSAL HEAD

**

17/07/2017 DAS 36 9-89

Location	Loc Qty	Loc Code
GA	821	
m136851	821	
ST310	780	
m136851	780	

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Shop Packet Print

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DQA: _____ Date: _____



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